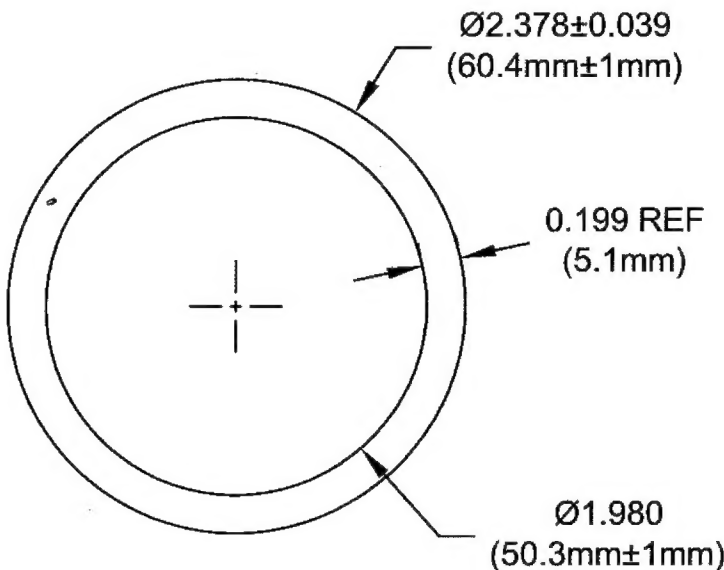


SPECIFICATION CONTROL DRAWING



NOTES

1) D6021-XXX CROSSTUBE

LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 125" LONG TUBE: D6021-125

2) MATERIAL: 17-4PH SEAMLESS STEEL TUBE PER ASTM A564
Ø2.378 O.D. x Ø1.980 I.D.

HEAT TREAT TO:
MIN. ULTIMATE TENSILE STRENGTH = 150 ksi
MIN. YIELD TENSILE STRENGTH = 140 ksi
MAX. YIELD TENSILE STRENGTH = 160 ksi

3) TOLERANCES ARE AS FOLLOWS:
ECCENTRICITY: 15% (+/-0.030" WALL)
LENGTH: XXX +0.188"/-0.000"
STRAIGHTNESS: 0.012" DEVIATION / 12" LENGTH

4) ALL DIMENSIONS ARE IN INCHES
5) TUBE MUST BE PICKLED OR ELECTROPOLISHED TO BE SMOOTH AND FREE FROM SCALE.
6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

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CP 12/9/12

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APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE MATERIAL	NTS
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